

# Work Order ID 72585

Tuesday, August 02, 2011 2:38:52 PM



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Item ID:	D2892-1	Accept		Setup	Start	
Revision ID:	<del>UNR</del>				Stop	
Item Name:	Support					
Start Date:	8/2/2011	Start Qty:	14.00			
Required Date:	8/2/2011	Req'd Qty:	14.00			
Reference:	ECN11-615	Rework				
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2892	Rev A <del>UNR</del>								

135		0.00							
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SprayPaint

Spray Painting

Memo

PULL FROM STOCK:  
14 X D2892-1 B70735

FOR THE ENTIRE INNER CONCAVE SURFACE:  
~ ABRADEN SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE  
WITH MEK  
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M  
SCOTCH-WELD 2216 BfA  
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR  
24 HOURS.

140	QC3- Inspect Part Finish	0.00							
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QC

Quality Control

Memo

0.00

25 11 08 15 (14)

14 11.08.16

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Item ID: D2892-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Support

Start Date: 8/2/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 14.00



Customer:

Reference: ECN11-615

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *K1116*

0.00



Packaging

Memo

0.00

Packaging

*25 11-08-16*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/8/18**11-08-16*  
*(14)*

# Picklist Print

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Work Order ID: 72585



Parent Item: D2892-1



Parent Item Name: Support

Start Date: 8/2/2011

Required Date: 8/2/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP C 02.11.26 Added P/O KJ  
IPP D 08.03.19 Re-format EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2892-1

Manufactured No

Each 0.0000

14



Support

144 70735

## List Lots

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Criteria : Item ID: d2892-1 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D2892-1 Support	Main Warehouse LG052	70735	7/29/2011	14.0000		QC21		
Total:				14.0000				

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**NOTES:**

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D8104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED

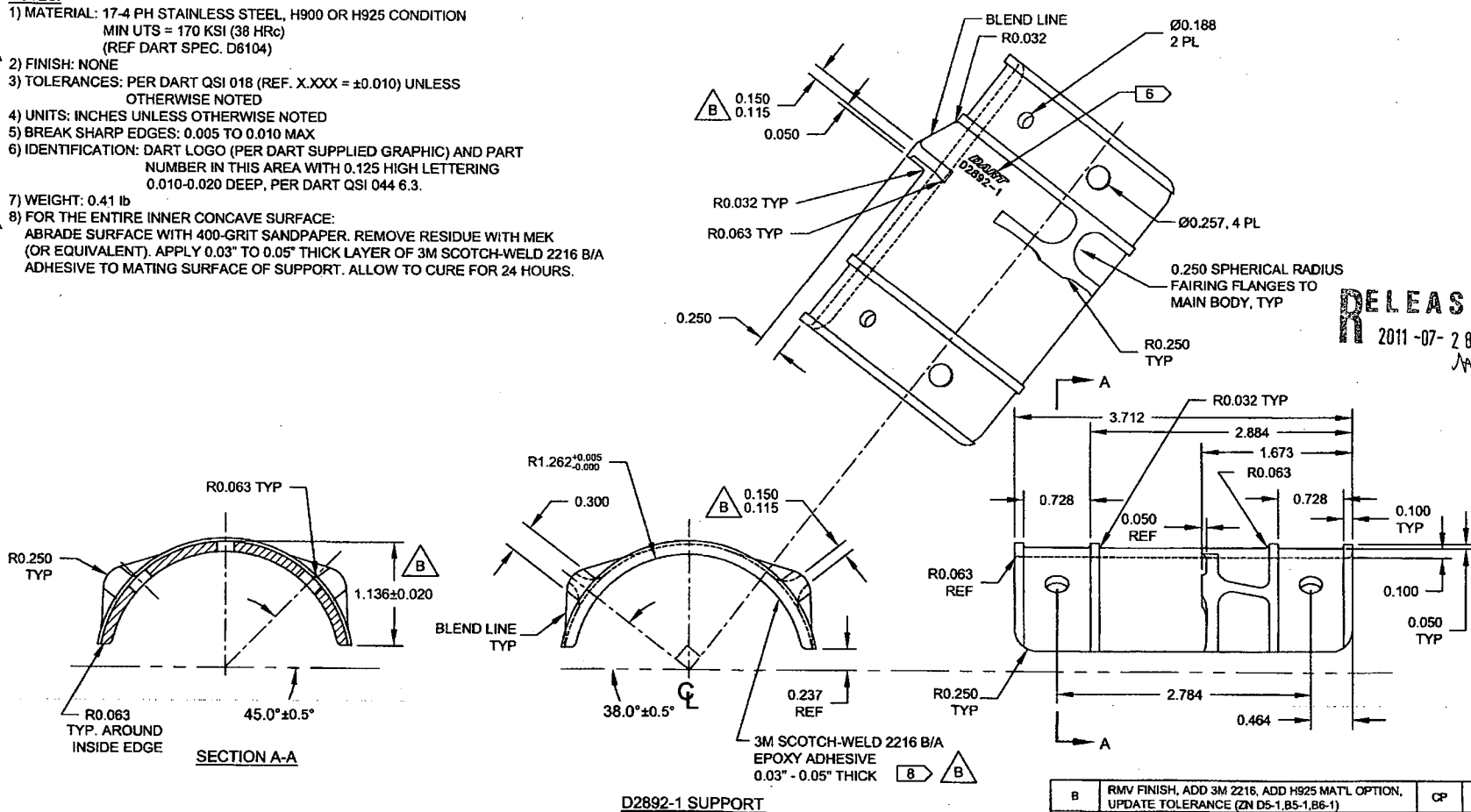
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING  
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



**RELEASED**  
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D5-1,B5-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	GP		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D2892

REV. B  
SHEET 1 OF 1

TITLE  
Ø2.500 SUPPORT

SCALE  
NTS

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